

Work Order ID 68497

Thursday, April 14, 2011 10:15:37 AM



Page 1

Item ID:	D412-630-031	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Pilot/Co-Pilot Step, LH (Folding)					
Start Date:	4/14/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	4/27/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>CL</u>	Date:	<u>11/04/14</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D412-630	Rev M								

100		0.00							
	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy D412-630 bluefile & type labels per PPP412-630-031 CHG003								

CL 11-5-27

5/16/27

110		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Assemble as per dwg D412-630 p.17								

****ensure tension to retract step is 11 to 18 lbs before installing lockwire.****

11/05/26

44

120		0.00							
	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control	****ensure tension to retract step is 11 to 18 lbs ****								

44

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68497

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Thursday, April 14, 2011 10:15:37 AM

Item ID: D412-630-031

Accept



Setup Start



Revision ID:

Stop



Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 4/14/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/27/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/5/06 SP

140

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8 11/05/27



150

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-630-031

Location: 31PPP Rev: D

11/5/07 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68497

Thursday, April 14, 2011 10:15:37 AM



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Item ID: D412-630-031

Accept



Setup Start



Revision ID:

Stop



Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 4/14/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/27/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/30

ME

11-05-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, April 14, 2011 10:15:31 AM

Page 1

Work Order ID: 68497

Parent Item: D412-630-031

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)



Start Date: 4/14/2011

Required Date: 4/27/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV. A 05.11.21 NEW ISSUE EC
IPP REV. B 05.12.19 updated pick list EC
IPP REV. C 07.11.12 ecn 1019,no chg EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN310-4 NUT		Purchased	No			130	Each	22.0000	1	1			
--------------------	--	-----------	----	--	--	-----	------	---------	---	---	--	--	--

Location Loc Qty Loc Code

ST324 22
116786 22

AN310-5 NUT		Purchased	No			130	Each	32.0000	2	2			
--------------------	--	-----------	----	--	--	-----	------	---------	---	---	--	--	--

Location Loc Qty Loc Code

ST324 32
114830 32

AN3C5A Bolt		Purchased	No			130	Each	1,077.000	3	3			
--------------------	--	-----------	----	--	--	-----	------	-----------	---	---	--	--	--

Location Loc Qty Loc Code

FP-A 7
115835 7
ST350 1070
115422 52
116419 418
116549 100
117343 500

1117442

2

3 11/5/26

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 68497

Parent Item: D412-630-031

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 4/14/2011

Required Date: 4/27/2011

Start Qty: 1.00

Required Qty: 1.00

AN44-C12

Purchased

No

130

Each

9.0000

1



eyebolt

Location

Loc Qty

Loc Code

ST362

9

114669

9

130

Each

8.0000

1

AN4C15

Purchased

No



BOLT

Location

Loc Qty

Loc Code

ST358

8

114669

8

130

Each

39.0000

1

AN5C11

Purchased

No



BOLT

Location

Loc Qty

Loc Code

ST337

39

113950

9

114801

30

130

Each

13.0000

1

AN5C15

Purchased

No



BOLT

Location

Loc Qty

Loc Code

ST338

13

114669

13

130

Each

0.0000

7

AN960C10

NAS1149C0363
R

Purchased

No



WASHER

Thursday, April 14, 2011 10:15:32 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 68497

Parent Item: D412-630-031

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 4/14/2011

Required Date: 4/27/2011

Start Qty: 1.00

Required Qty: 1.00

AN960CS16

Purchased No

130 Each

55.0000

1

1



WASHER

Location

Loc Qty

Loc Code

ST347

55

102842

55

Manufactured No

130 Each

26.0000

1

1

D3454-1



Bushing

Location

Loc Qty

Loc Code

ST054

26

58555

26

Manufactured No

130 Each

0.0000

2

2

D3454-3



Bushing

D3454-5



Bushing

Manufactured No

130 Each

3.0000

2

2

Location

Loc Qty

Loc Code

ST054

3

58556

3

Manufactured No

130 Each

13.0000

4

4

D3455-1



Spacer

Location

Loc Qty

Loc Code

ST054

13

59469

13

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Work Order ID: 68497

Parent Item: D412-630-031

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 4/14/2011

Required Date: 4/27/2011

Start Qty: 1.00

Required Qty: 1.00

D3455-3

Manufactured No

130 Each

8.0000

2



Spacer

Location

Loc Qty

Loc Code

ST054

8

58559

8

130 Each

3.0000

1

D3462-041

Manufactured No



Bracket Assembly

Location

Loc Qty

Loc Code

ST198A

3

60572

3

130 Each

998.0000

3

MS21043-3

Purchased No



Nut

Location

Loc Qty

Loc Code

FG

80

103691

80

FP-B

-5

112314

-5

ST301

923

112314

923

130 Each

46.0000

2

MS24665-227

Purchased No



COTTER PIN

Location

Loc Qty

Loc Code

ST309

46

113845

46

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Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 68497

Parent Item: D412-630-031

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 4/14/2011

Required Date: 4/27/2011

Start Qty: 1.00

Required Qty: 1.00

MS24665-229

Purchased

No

130

Each

135.0000



COTTER PIN

Location

Loc Qty

Loc Code

ST309

135

111041

135

Purchased

No

130

Each

171.0000

NAS1515H5



Washer

Location

Loc Qty

Loc Code

FG

40

103286

20

103691

20

ST277

131

109430

131

Manufactured

No

110

Each

1.0000

D3463-041



Step Weldment Assembly

Location

Loc Qty

Loc Code

ST494

1

56064

1

Manufactured

No

110

Each

1.0000

D3443-043



Strut Weldment Assembly

Location

Loc Qty

Loc Code

ST198A

1

56062

1

Thursday, April 14, 2011 10:15:33 AM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 68497



Parent Item: D412-630-031



Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 4/14/2011

Required Date: 4/27/2011

Start Qty: 1.00

Required Qty: 1.00

D3443-041



Strut Weldment Assembly

Manufactured No

110 Each

3.0000

1

1



ES 11/05/26

Location

Loc Qty

Loc Code

ST198A

3

56061

3

D3443-9



Pin

Manufactured No

110 Each

2.0000

2

2



ES 11/05/26
B68475 (20)

Location

Loc Qty

Loc Code

ST053

2

58552

2

D3454-7



Bushing

Manufactured No

110 Each

14.0000

2

2



ES 11/05/26

Location

Loc Qty

Loc Code

ST054

14

59256

14

D3455-1



Spacer

Manufactured No

110 Each

13.0000

2

2



ES 11/05/26

Location

Loc Qty

Loc Code

ST054

13

59469

13

D3465-1



Washer

Manufactured No

110 Each

24.0000

1

1



ES 11/05/26

Location

Loc Qty

Loc Code

ST054

24

46134

24

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Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, April 14, 2011 10:15:33 AM

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Work Order ID: 68497

Parent Item: D412-630-031

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 4/14/2011

Required Date: 4/27/2011

Start Qty: 1.00

Required Qty: 1.00

AN4CH3	Purchased	No	110	Each	13.0000	2	2	EP 11/05/26
SS Bolt								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST355	13				
			114801	13				
AN4CI4	Purchased	No	110	Each	20.0000	1	1	EP 11/05/26
BOLT								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST358	20				
			114669	20				
AN310-4	Purchased	No	110	Each	22.0000	1	1	EP 11/05/26
NUT								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST324	22				
			116786	22				
AN310-7	Purchased	No	110	Each	47.0000	1	1	EP 11/05/26
NUT								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST324	47				
			114784	47				
MS24665-227	Purchased	No	110	Each	46.0000	1	1	EP 11/05/26
COTTER PIN								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST309	46				
			113845	46				

Thursday, April 14, 2011 10:15:34 AM

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 68497



Parent Item: D412-630-031



Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 4/14/2011

Required Date: 4/27/2011

Start Qty: 1.00

Required Qty: 1.00

MS24665-302

Purchased

No

110

Each

22.0000

1

1



Cotter Pin



ES 11/05/26

Location

Loc Qty

Loc Code

ST309

22

113644

22

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

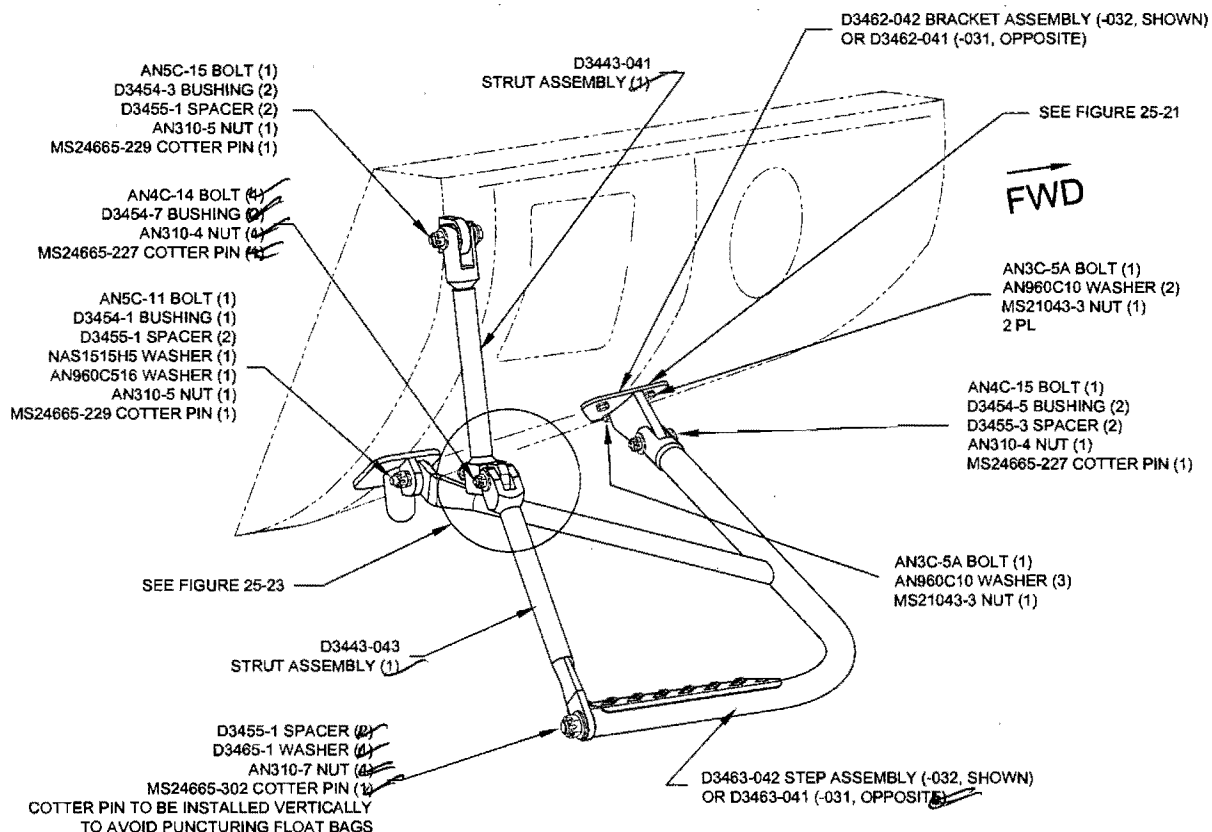


FIGURE 25-22: Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)

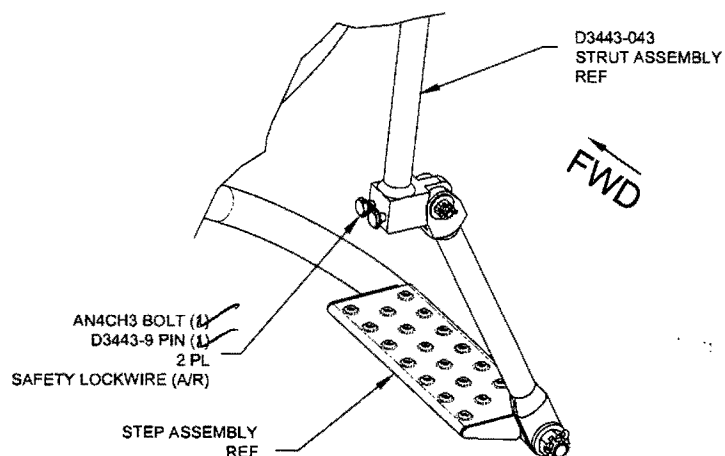


FIGURE 25-23: Detail Safety Wiring, D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)

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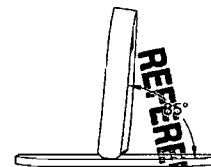
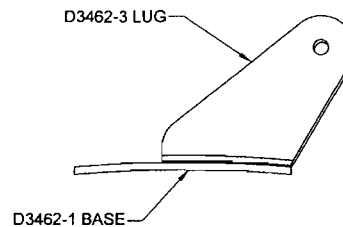
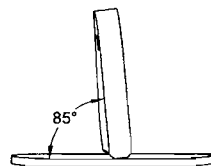
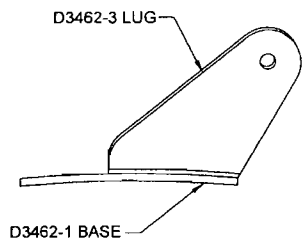
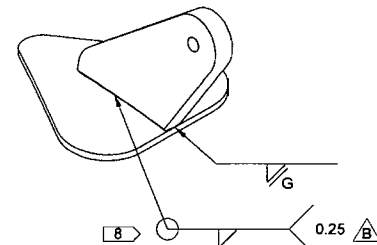
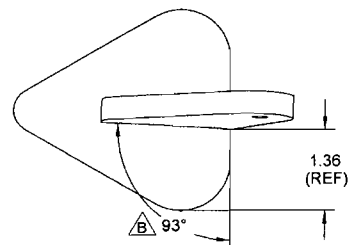
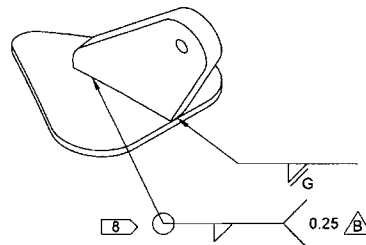
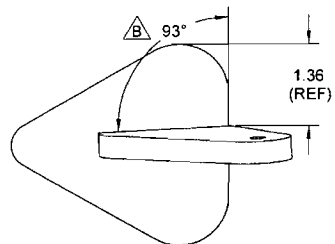
D412-630
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Qty -031	Qty -032	Part Number	Description
X		D412-630-031	PILOT/CO-PILOT STEP, LH (FOLDING)
	X	D412-630-032	PILOT/CO-PILOT STEP, RH (FOLDING)
1	1	D3443-041	STRUT ASSEMBLY
1	1	D3443-043	STRUT ASSEMBLY
2	2	D3443-9	PIN
1	1	D3454-1	BUSHING
2	2	D3454-3	BUSHING
2	2	D3454-5	BUSHING
2	2	D3454-7	BUSHING
4 6	6	D3455-1	SPACER (-2)
2	2	D3455-3	SPACER
1		D3462-041	BRACKET ASSEMBLY
	1	D3462-042	BRACKET ASSEMBLY
1	1	D3463-041	STEP ASSEMBLY
	1	D3463-042	STEP ASSEMBLY
1	1	D3465-1	WASHER
2	2	AN310-4	NUT -1
2	2	AN310-5	NUT
1	1	AN310-7	NUT
3	3	AN3C-5A	BOLT
1	1	AN44-C12	* EYEBOLT
1	1	AN4C14	BOLT
1	1	AN4C15	BOLT
2	2	AN4C13	BOLT
1	1	AN5C11	BOLT
1	1	AN5C15	BOLT
7	7	AN960C10	WASHER
1	1	AN960C516	WASHER
3	3	MS21043-3	NUT
2	2	MS24665-227	COTTER PIN (-1)
2	2	MS24665-229	COTTER PIN
1	1	MS24665-302	COTTER PIN
1	1	NAS1515H5	WASHER

*USE AN44-C12 EYEBOLT WHEN D412-630-031/-032 IS INSTALLED IN CONJUNCTION WITH D412-630-023/-024/-033/-034TM HELI-ACCESS-STEP

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Revision: **M**
Date: 08.12.12



D3462-041 BRACKET ASSEMBLY

D3462-042 BRACKET ASSEMBLY

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3462-041	BRACKET ASSEMBLY
	X	D3462-042	BRACKET ASSEMBLY
1	1	D3462-1	BASE
1	1	D3462-3	LUG

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3462-041" OR "D3462-042" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.75 lbs (TYP)
- 8) WELDING: PER DART QSI 004

C	SHOW VIEWS OF D3462-041 & D3462-042, UPDATE DWG REASON: PRODUCTION FACILITY	DC	07.10.24
B	REVISE DIMENSIONS	RF	05.12.05
A	NEW ISSUE	RF	05.09.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.10.24		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3462 TITLE BRACKET ASSEMBLY SCALE 1:2 REV. C SHEET 1 OF 2 COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

REFERENCE ONLY

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